

Date: Wednesday, 11/02/2009 1:18:23 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL LOCK ASSY
Job Number	: 45749		
Estimate Number	: 13076		
P.O. Number	:	Part Number	: D3370051 - 021 <i>11.04.20</i>
This Issue	: 11/02/2009 S.O. No. :	Drawing Number	: D3370 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 44257	Material	:
Written By	:	Due Date	: 28/02/2009
Checked & Approved By	: <u>JUL 09.02.11</u>	Qty:	3 Um: Each
Comment	: Est. a 07.11.29 new issue EC Est Rev:B 08-07-17 revC as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33701	Pedal Lock Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pedal Lock Base

BATCH B44287

2.0	D33703	Pedal Lock Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pedal Lock Cover

BATCH B44288

3.0	D33735	Cam Lock
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Cam Lock

BATCH B22383

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

4.0	D33853	Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)





Hinge

BATCH B22387

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370-051 PAR #: N/A Fault Category: Prod / Machined Part NCR: Yes No DQA: D Date: 09/02/12
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/12

NCR: <u>45749</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-12	2.0	Upon assembly Qty 1 D3370-3 was found with the hinge cable hole on the wrong side of the part. Machinist placed the part incorrectly in the machine. R.C: Lack of Attention machining.		part is scrap: not worth re-working. Destroy: no replace (replace for Assy)	EB 09/02/12			

NOTE: Date & initial all entries

Date: Wednesday, 11/02/2009 1:18:23 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK ASSY

Job Number: 45749

Part Number: D3370051

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN526C832R6

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Screw

BATCH M16612

Ep509/02/17

6.0

D27287

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Decal

BATCH B 22554

Ep509/02/17

7.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

1/4"-20 SHCS 3/8" long

BATCH A16971

Ep509/02/17

8.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

BATCH M119356

Ep509/02/17

9.0

D3384041

Cyclic Sock Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cyclic Sock Assembly

BATCH B44311

Ep509/02/17

10.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

3/16" Dowel Pin .5" long

BATCH B17278

Ep509/02/17

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3370

Ep509/02/17 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/02/2009 1:18:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK ASSY

Job Number: 45749

Part Number: D3370051

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 09/02/19 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Right 23 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24 J

Job Completion



MF 09-02-24

C512A

CY18A

C516A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

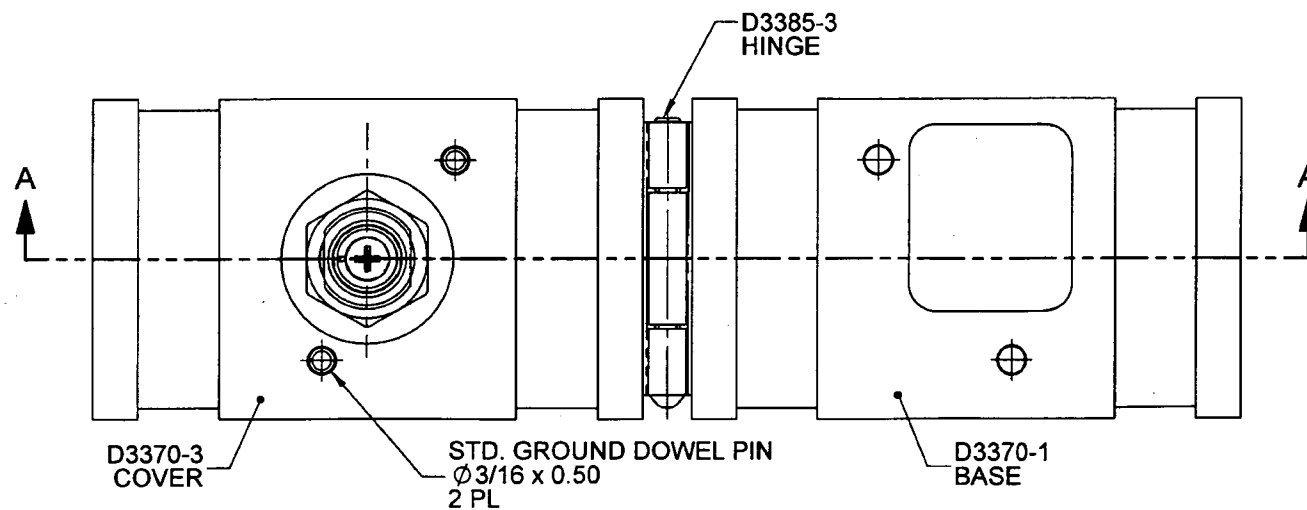
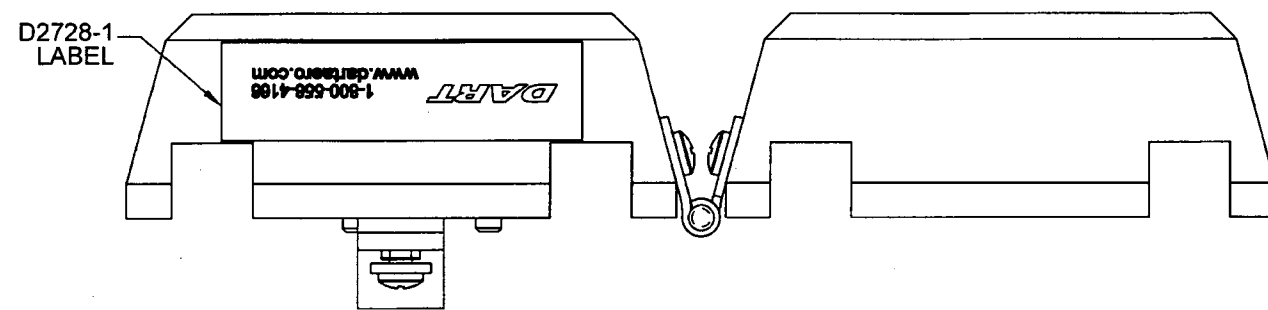
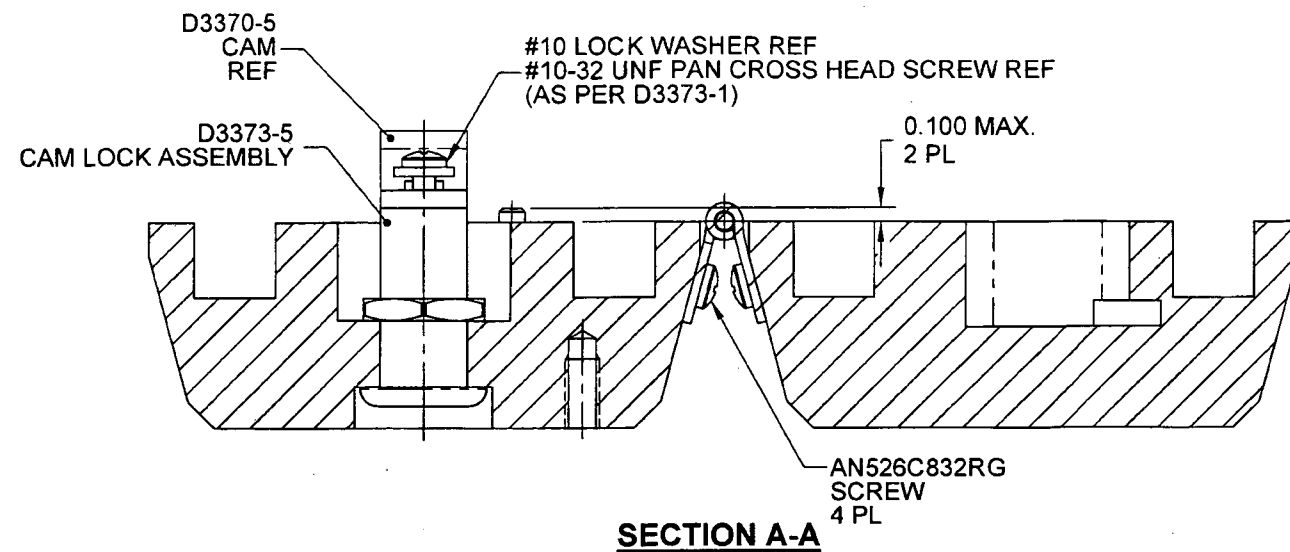


Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

RELEASED
08.07.11

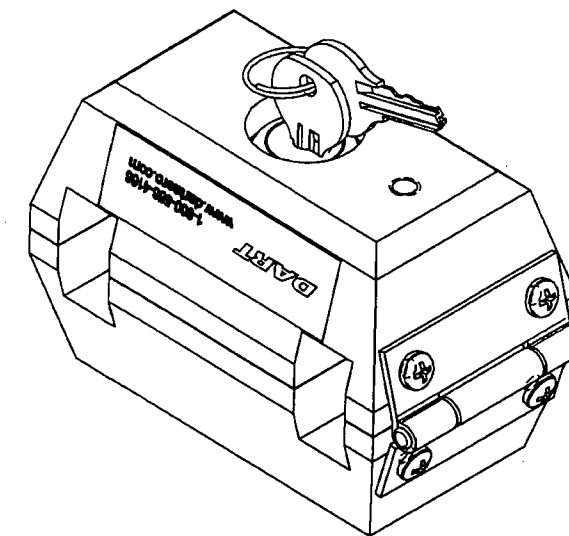
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WORK ORDER
NO. 45749

C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3370	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
DATE	08.07.11		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3370-051 PEDAL LOCK ASSEMBLY

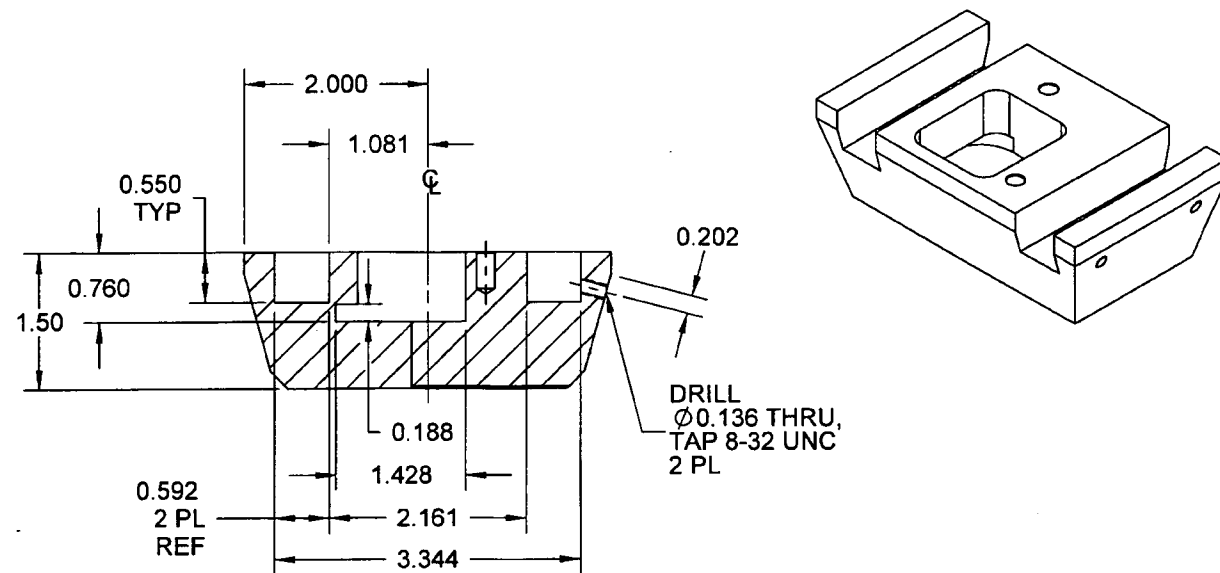
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs



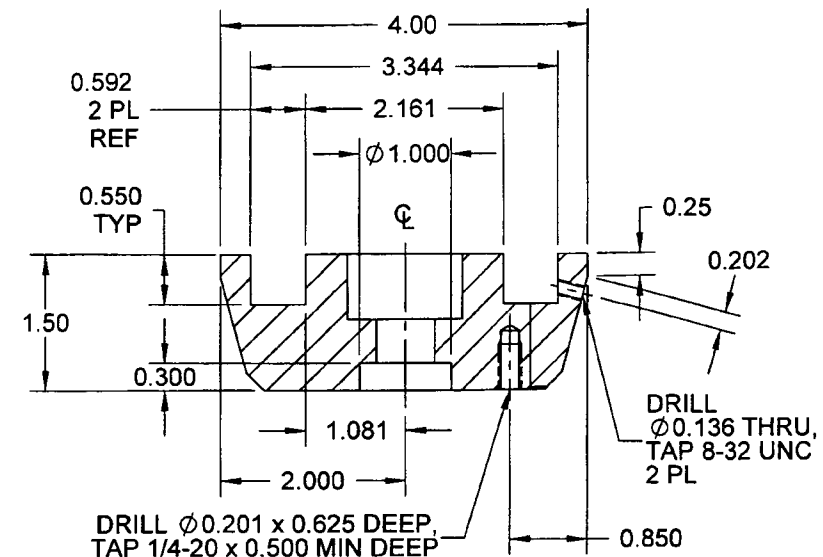
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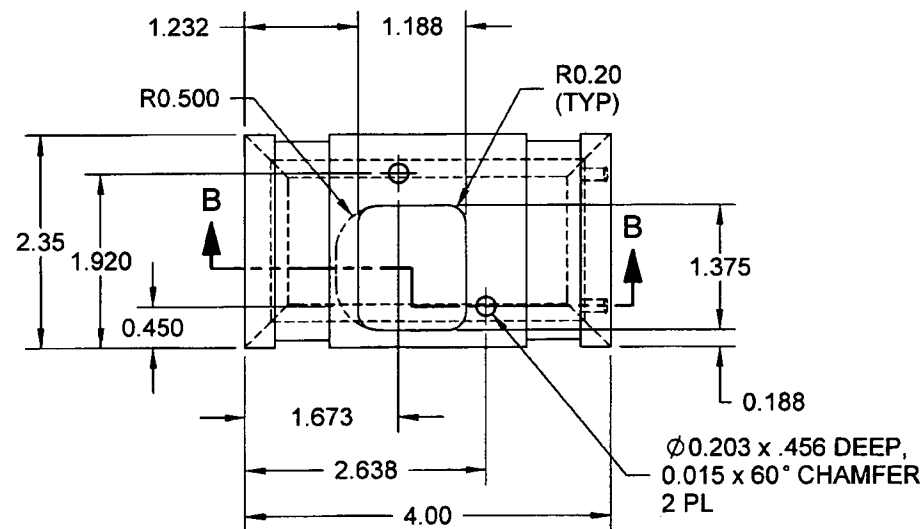
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MFG. APPR.		D3370	SHEET 2 OF 4
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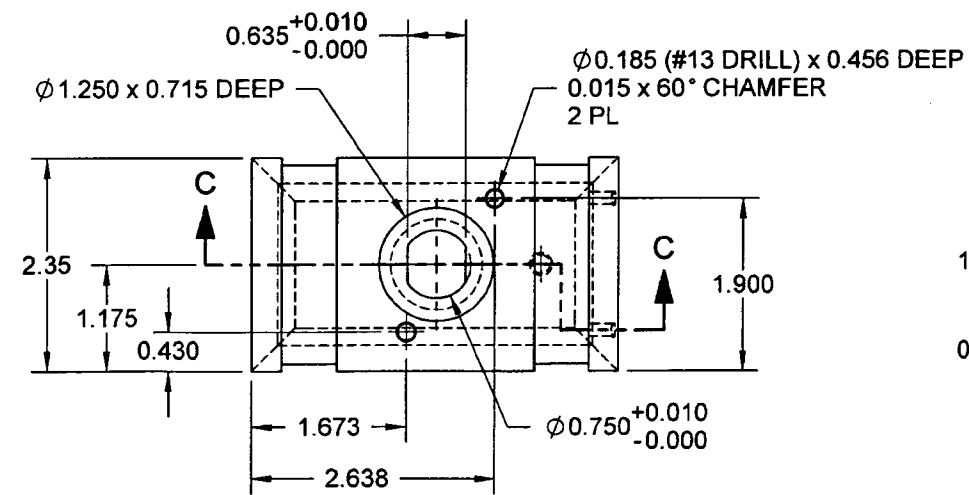
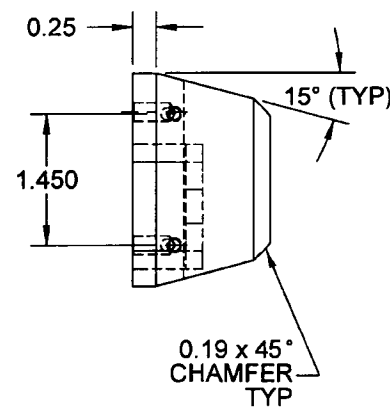
SECTION B-B



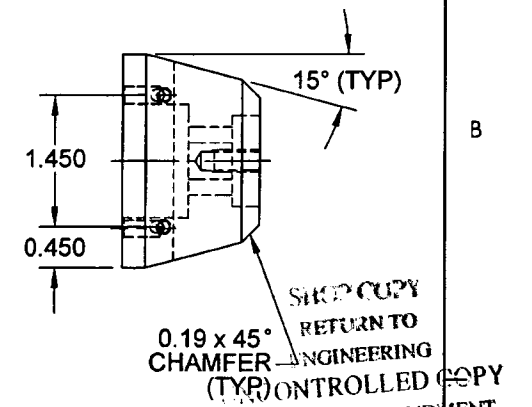
SECTION C-C



D3370-1 BASE



D3370-3 COVER

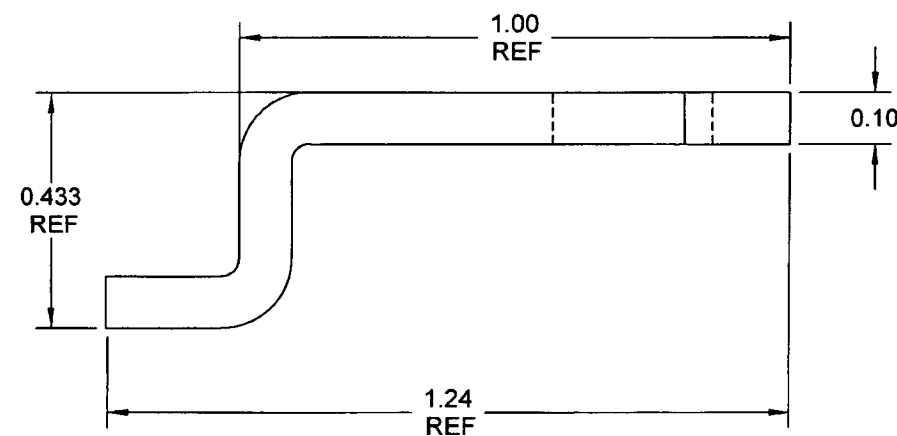
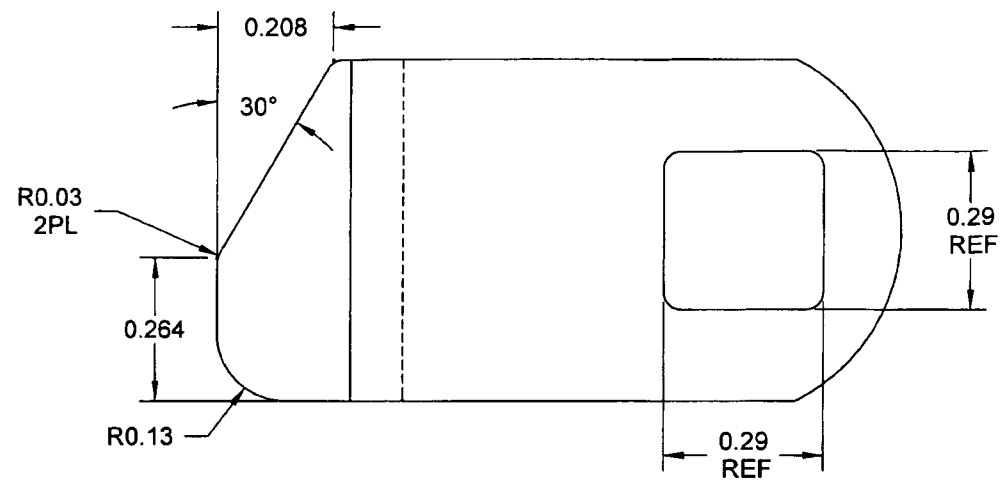


NOTES:

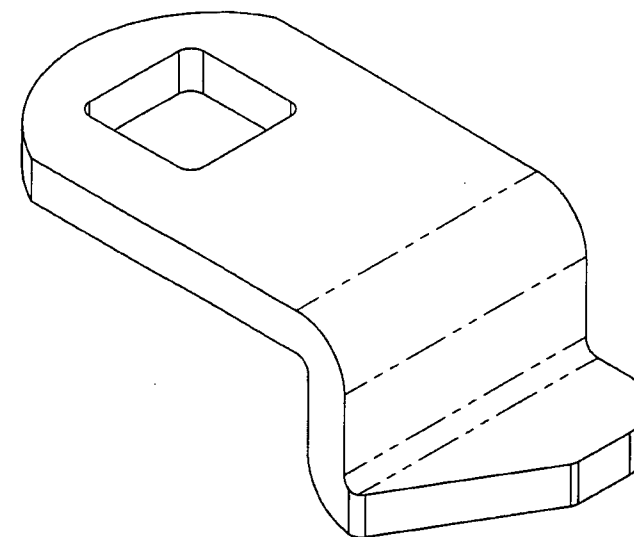
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
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DE APPR.		PEDAL LOCK	NTS
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RELEASED
08-07-16
45-749



D3370-5 CAM



- NOTES:**
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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